

Work Order ID 68800

Thursday, April 21, 2011 7:30:19 AM

Page 1

Item ID: D2873-045

Accept

Setup Start

Revision ID:

Stop

Item Name: Nut Plate Assembly

Start Date: 4/21/2011 Start Qty: 20.00

Cust Item ID:

Required Date: 4/27/2011 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start

QC: Date: SPC (Y/N): Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2873	Rev A

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 1.000" x 0.375" x 2.700" long

On 11/04/27

20

/

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per Folio FA and Dwg D2873 Identify as D2873-5
Dwg Rev 4 F1819Folio Rev AA

PR. 11.5.2

20

/

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

PR 11.5.2

20

/

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

JL 1165103



QC

Memo

0.00

Quality Control

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Deburr □2- C'sink as per Dwg D2873

JS 4/25/13 (20)

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 1165103

counts
(20)

W/O:		WORK ORDER CHANGES					
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Page 3

Thursday, April 21, 2011 7:30:19 AM

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Revision ID: Stop 
Item Name: Nut Plate Assembly
Start Date: 4/21/2011 Start Qty: 20.00  Cust Item ID:
Required Date: 4/27/2011 Req'd Qty: 20.00  Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start 
QC: Date: SPC (Y/N): Date: Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				20	0	11-5-03	
170  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				20	0	11-5-3	
180  Small Fab Small Fab	Small Fab Memo 1-Assemble as per Dwg D2873 <input type="checkbox"/> 2-Identify as D2873-045	0.00 0.00						11/05/03	(20)

W/O:		WORK ORDER CHANGES					
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Thursday, April 21, 2011 7:30:19 AM



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Item ID: D2873-045

Accept



Setup Start



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Stop



Item Name: Nut Plate Assembly

Start Date: 4/21/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 4/27/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

0.00 *8/10/13*

Memo

20
(20)

200



Packaging

Packaging

Identify as per dwg & Stock Location: *x-tube*
Ass'y

0.00

0.00

Memo

11-05-04 *(20)*

210



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

Memo

11/5/4 *(20)**11-05-9**(20)*

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, April 21, 2011 7:30:26 AM

Work Order ID: 68800

Parent Item: D2873-045

Parent Item Name: Nut Plate Assembly




Start Date: 4/21/2011

Required Date: 4/27/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP AL 05.09.13 New issue KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21075L5  Nut Plate		Purchased	No			100	Each	46.0000	2	40			
<div> <div> <u>Location</u> ST303 116914 </div> <div> <u>Loc Qty</u> 46 46 </div> <div> <u>Loc Code</u> </div> </div>													
M6061T6B0.375X01.00 0  6061T6 BAR .375 x 1.00		Purchased	No			180	f	18.6426	0.225	4.736842			
<div> <div> <u>Location</u> MAT002 116963 </div> <div> <u>Loc Qty</u> 18.6426 18.6426 </div> <div> <u>Loc Code</u> </div> </div>													
MS20426AD4-6  Rivet		Purchased	No			180	Each	1,204.000	4	80			
<div> <div> <u>Location</u> ST317 110139 </div> <div> <u>Loc Qty</u> 1204 1204 </div> <div> <u>Loc Code</u> </div> </div>													

EP 11/05/03
M117557 15x

RP 11.5.2

4.736
80

50 EP 11/05/03

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DART AEROSPACE LTD		Work Order:	68800
Description: Radius Block		Part Number:	D2873-5
Inspection Dwg: D2873 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.50	+/-0.030	2.500	/		RCP .02	
1.000	+/-0.010	1.000	/			
0.750	+/-0.010	.749	/			
0.250	+/-0.010	.252	/			
1.000	+/-0.010	1.000	/			
2.000	+/-0.010	2.001	/			
Ø0.128	+0.005/-0.001	.128	/			
0.359	+/-0.010	.359	/			
Ø0.316	+0.006/-0.001	.316	/			
1.000	+/-0.010	1.000	/			
0.250	+/-0.010	.251	/			
0.061	+/-0.010	.060	/			
Ø0.230 x 0.125	+0.005/-0.001 x 0.010	.228 x .128	/			

Measured by: RCP	Audited by: J	Prototype Approval:	N/A
Date: 11.5.2	Date: 11/05/03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.08.30	New Issue P/O D2873-045	KJ/JLM	[Signature]

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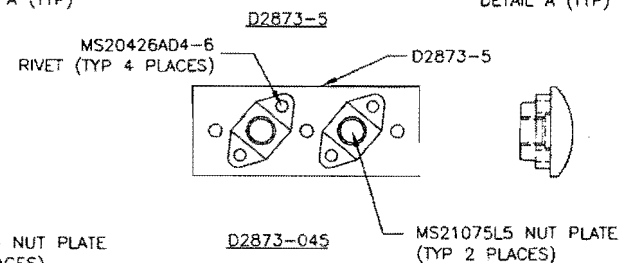
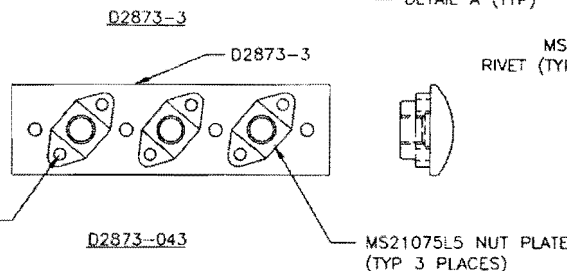
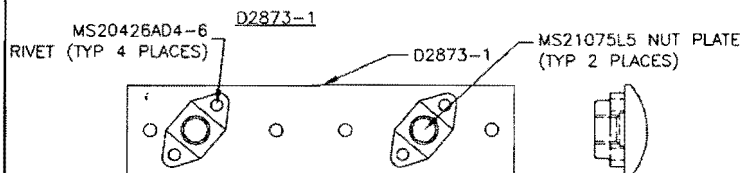
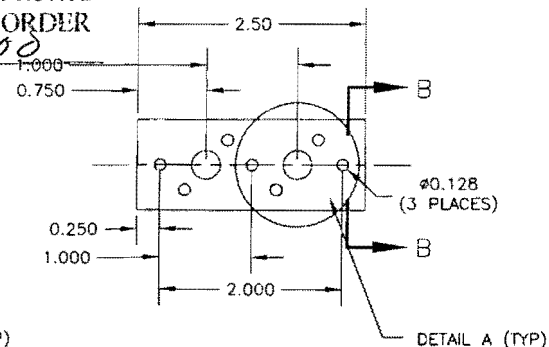
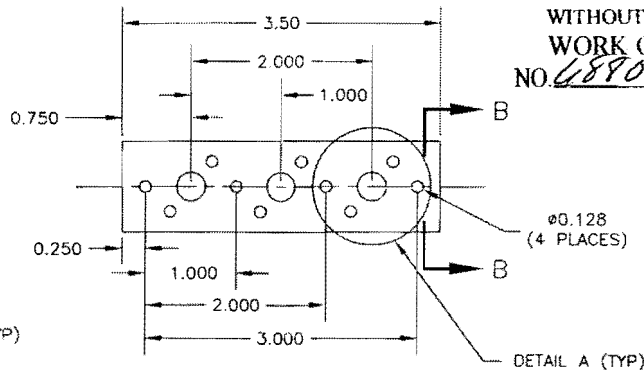
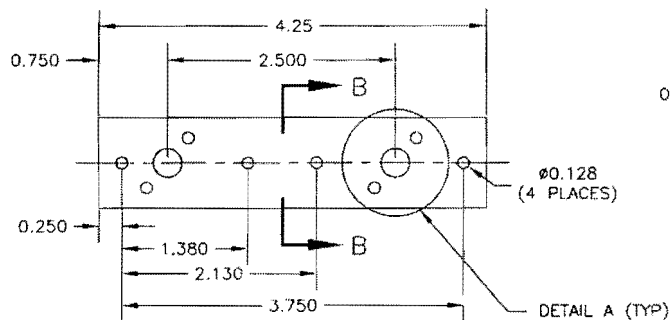
NOTE: Date & initial all entries

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 48900

11-04-21



D2873-1/-3/-5 RADIUS BLOCK

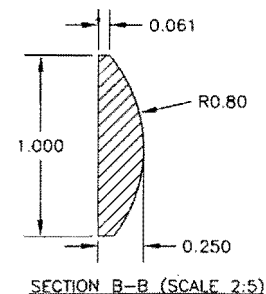
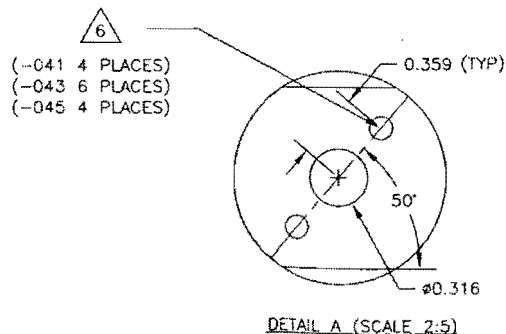
- 1) MATERIAL: 5052-H32/H34 BAR (QQ-A-225/7) (REF. DART SPEC M5052H32B1.000X00.250) OR 6061-T6 BAR (QQ-A-225/8 OR QQ-A-200/8) (REF. DART SPEC M6061T6B1.000X00.250)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 6) Ø0.128 PILOT + C'BORE CURVED SIDE Ø0.230X0.125 DEEP + C'SINK CURVED SIDE Ø0.225 x 100'

D2873-041/-043/-045 NUT PLATE ASSEMBLY

- 1) INSTALL MS21075L5 NUT PLATE IN ORIENTATION SHOWN USING MS20426AD4-6 RIVETS

D2873-041/-043/-045 NUT PLATE ASSEMBLY PARTS LIST

-041	-043	-045	PART NUMBER	DESCRIPTION
X			D2873-041	NUT PLATE ASSEMBLY
	X		D2873-043	NUT PLATE ASSEMBLY
		X	D2873-045	NUT PLATE ASSEMBLY
1			D2873-1	RADIUS BLOCK
	1		D2873-3	RADIUS BLOCK
		1	D2873-5	RADIUS BLOCK
4	6	4	MS20426AD4-6	RIVET
2	3	2	MS21075L5	NUT PLATE



RELEASED
11-05-07-26

A	05.07.26	NEW ISSUE
DESIGN	PH	DRAWN BY PH
CHECKED	PH	APPROVED
DATE	05.07.26	TITLE
		RADIUS BLOCK
		SCALE 4:5

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